

Work Order ID 62986

Friday, October 15, 2010 8:31:59 AM



Page 1

Item ID:	D3826-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib / Gusset Assembly				Stop	
Start Date:	10/15/2010	Start Qty:	6.00			
Required Date:	10/19/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:		Date:	10-10-15	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3826	Rev B								

100		Large Fab	0.00							
Large Fab		Memo	0.00							
Large Fab		1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod								
		Batch: 111585								
110		QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC		Memo	0.00							
Quality Control										
120		QC5- Inspect part completeness to step on W/O	0.00							
QC		Memo	0.00							
Quality Control										

⑥ PL 10-10-19

⑥ PD 10.10.20

6 10-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3826-041

Accept



Setup Start



Revision ID:

Item Name: Rib / Gusset Assembly

Stop



Start Date: 10/15/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/19/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: WA

0.00

SAD

10-10-20



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/20

ME
10-10-20

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Friday, October 15, 2010 8:32:04 AM

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into its components and identifying the underlying causes.

3. The third step is to develop a plan. This involves determining the steps that need to be taken to solve the problem.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.




5. The fifth step is to evaluate the results. This involves assessing the effectiveness of the solution and making adjustments as needed.

[illegible]

Required Date: 10/19/2010

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2235-1  Basket Rib		Manufactured	No				Each	14.0000	1	6			
				<u>Location</u>									
				WA				14					
					61471			4					
					62254			10					
D3929-041  Gusset Assembly		Manufactured	No				Each	5.0000	1	6			
				<u>Location</u>									
				WA				5					
					61472			5					
D3929-042  Gusset Assembly		Manufactured	No				Each	6.0000	1	6			
				<u>Location</u>									
				WA				6					
					61473			6					

W/O:		WORK ORDER CHANGES					
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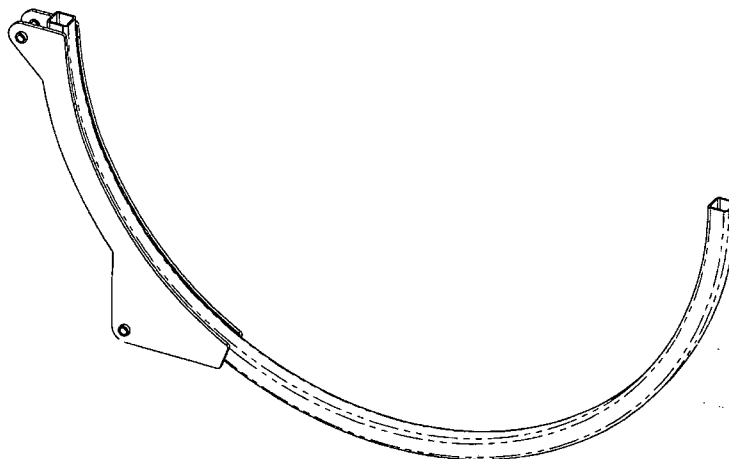
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURNED
ENGINEER
UNCONTROLLED
SUBJECT TO APPROVAL
WITHIN 30 DAYS
WORK ORDER
NO. 62984
PS 10-10-15

RELEASED
5/10/12 MB

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.32 lbs

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.		MB	09.04.16
A	NEW ISSUE		MB	08.09.23
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.16			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3826	REV. B SHEET 1 OF 2
TITLE RIB/GUSSET ASSY	SCALE NTS
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△ B D3929-042
GUSSET ASSEMBLY

△ B D3929-041
GUSSET ASSEMBLY

TYP

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

w/ 6298

RELEASED
9/10/42

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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